

Work Order ID 60679

Monday, July 19, 2010 10:17:09 AM

Page 1

Item ID: D2654-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Web

Start Date: 7/19/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 7/23/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-7-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2654	Rev E1								
100		0.00							
Skid tubes									
Skid tubes	Memo	0.00							
Skid tubes	1-Cut D2600-7 to length as per Dwg D2654 □2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654 □3-Using the uni-bit, open holes to finish size as per Dwg D2654 □4-Deburr holes and ends								
110		0.00							
QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
120		0.00							
Hand Finish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

4 - - AWM 10-07-19

x 4 BB 10/07/19

4 - - AWM 10-07-19 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60679

Monday, July 19, 2010 10:17:09 AM



Page 2

Item ID: D2654-5

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 7/19/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/23/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 M 2077/2L

140

Identify as per dwg & Stock Location: L.G

0.00



Packaging

Memo

0.00

Packaging

4 - - AWM 10-07-10

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

100720
MF
10-7-20

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, July 19, 2010 10:17:13 AM

Page 1

Work Order ID: 60679



Parent Item: D2654-5



Parent Item Name: Web

Start Date: 7/19/2010

Required Date: 7/23/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-7-140

Manufactured

No

100

Each

58.0000

1

4



EXT. "I BEAM" THICK

Location

Loc Qty

Loc Code

LG

58

58

41591

AWM 10-07-19 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

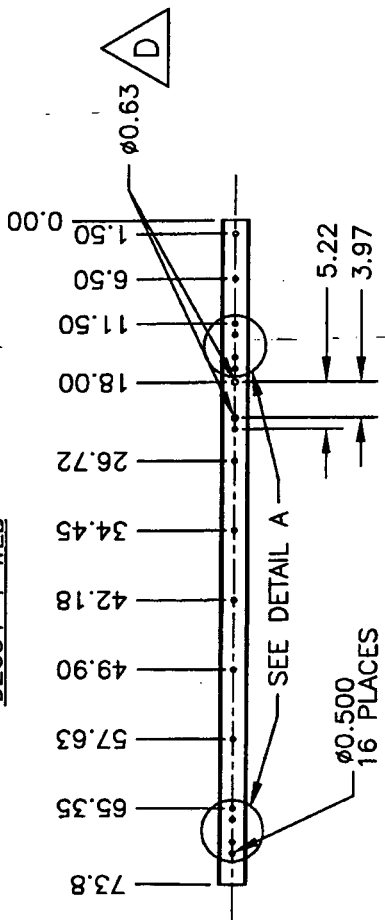
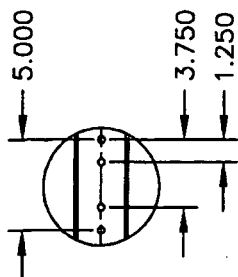
DART

DEO ATTACHED

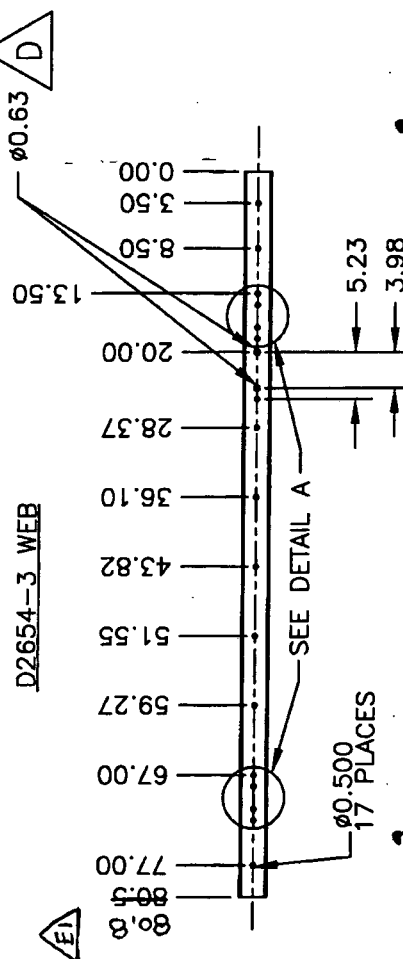
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04.06.22

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	REV. E
				PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO. D2654	SHEET 1 OF 2
DATE	04.05.26	TITLE	WEB	SCALE	1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO Ø0.63			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	CP # 04.08.24	PER TOOLING; 80.8 WAS 80.5			

D2654-1 WEB

DETAIL A
SCALE 1:10

D2654-3 WEB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60079 P10-719MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005:4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART

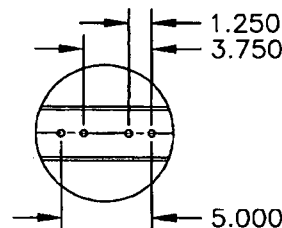


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	04.05.26	DRAWING NO.	D2654	REV. E
		TITLE	WEB	SHEET 2 OF 2
		SCALE	1:20	

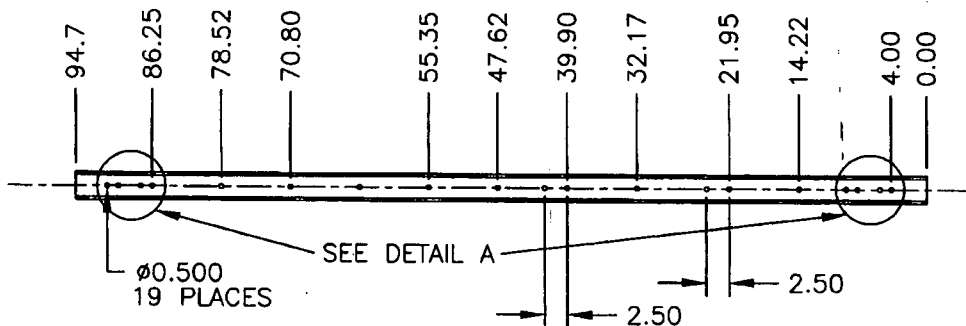
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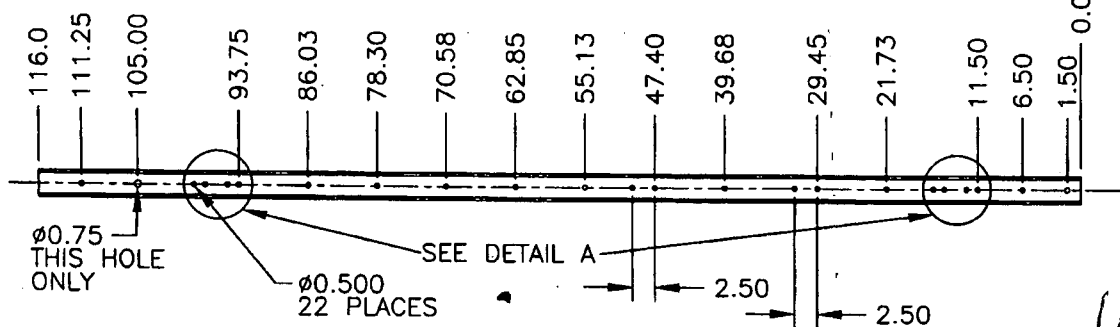
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



21060629

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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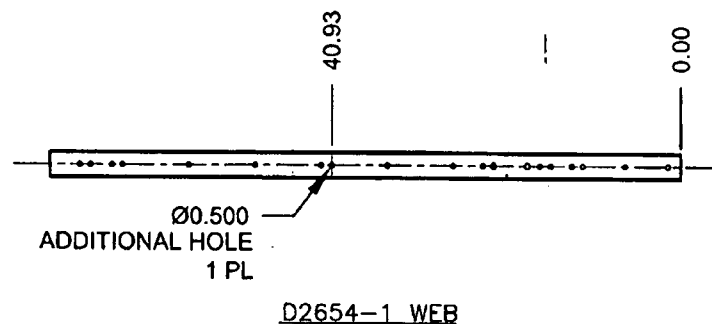
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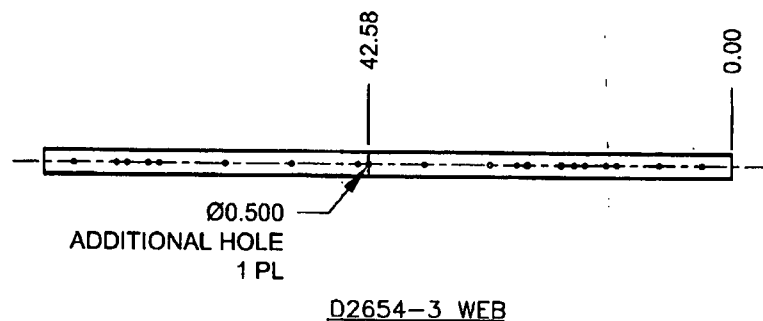
DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>LP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>CE</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03		DATE 09.04.03		

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/03 *MP*



w/o 60679



THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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